

Work Order ID 83945

April-27-12 2:54:17 PM

83945

Page 1

Item ID: D2803-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 27/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2803	Rev B

100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Press D2805-2 and D2809 into arm as per Dwg D2803								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>1:20</u> OVEN TEMPERATURE: <u>200</u>								
	FINISH TIME: <u>3:20</u>								

W121134

320015

200

6X 12/06/05

6 12/06/05

6X 12/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>55149</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/6/8 

112-06-7

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Picklist Print

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Page 1

Work Order ID: 83945

83945

Parent Item: D2803-042

D2803-042

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-2 *D2803-2* Bracket		Manufactured	No			100	Each	3.0000	1	4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST148			3					
					79178			3					
D2805-2 *D2805-2* Stop		Manufactured	No			100	Each	13.0000	1	4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					GA			13					
					81073			13					
NAS1515H3 *NAS1515H3* Washer		Purchased	No			100	Each	190.0000	4	16			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST277			190					
					118078			6					
					119438			4					
					120142			11					
					120518			26					
					120770			43					
					121415			100					

PS 12/06/05
B82662
(24)
PS 12/06/05
6
PS 12/06/06
M121649
(24)

W/O:		WORK ORDER CHANGES					
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Work Order ID: 83945

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Parent Item: D2803-042

D2803-042

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C16A

Purchased

No

150

Each

68.0000

2

8

AN3C16A

Bolt

**

EB 12/06/06

Location

Loc Qty

Loc Code

ST352

68

115835

1

118422

4

120498

38

121349

25

12

D2809

Manufactured

No

150

Each

40.0000

1

4

D2809

Bushing

**

EB 12/06/06

Location

Loc Qty

Loc Code

GA

24

72735

7

80557

17

ST018

16

34035

12

77292

4

6

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Parent Item: D2803-042

Parent Item Name: Bracket Assembly

83945

D2803-042

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

150

Each

1,097.000

2

8

MS21043-3

Nut

**

EP 12/06/06

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

124

120693

124

ST301

901

118077

2

118614

83

118686

30

119758

20

121255

766

6

M121708
(6A)

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Shop Packet Print

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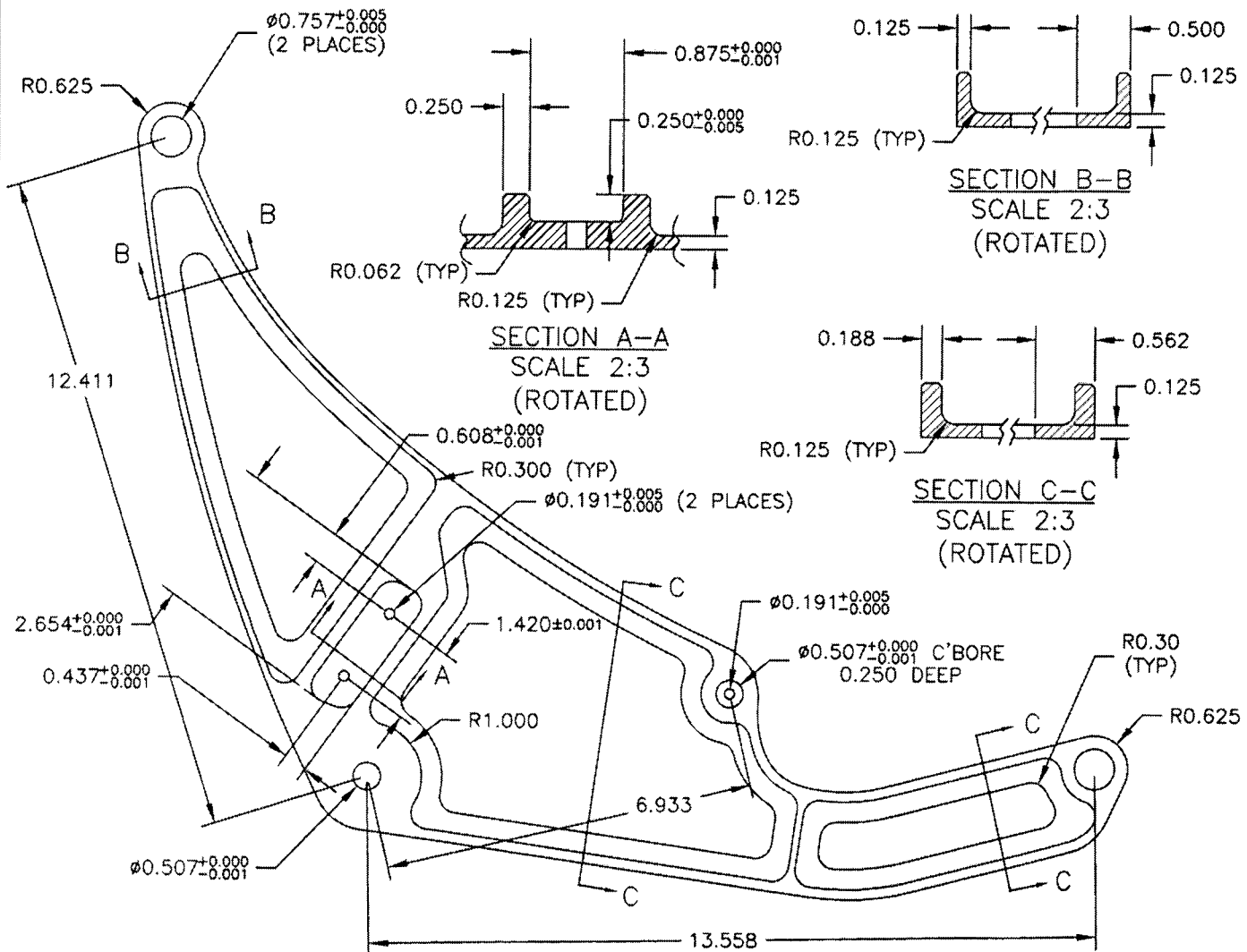
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DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03 11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 03948 MCJ
12/04/23

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SHOP COPY
RETURN TO

W/O:		WORK ORDER CHANGES					
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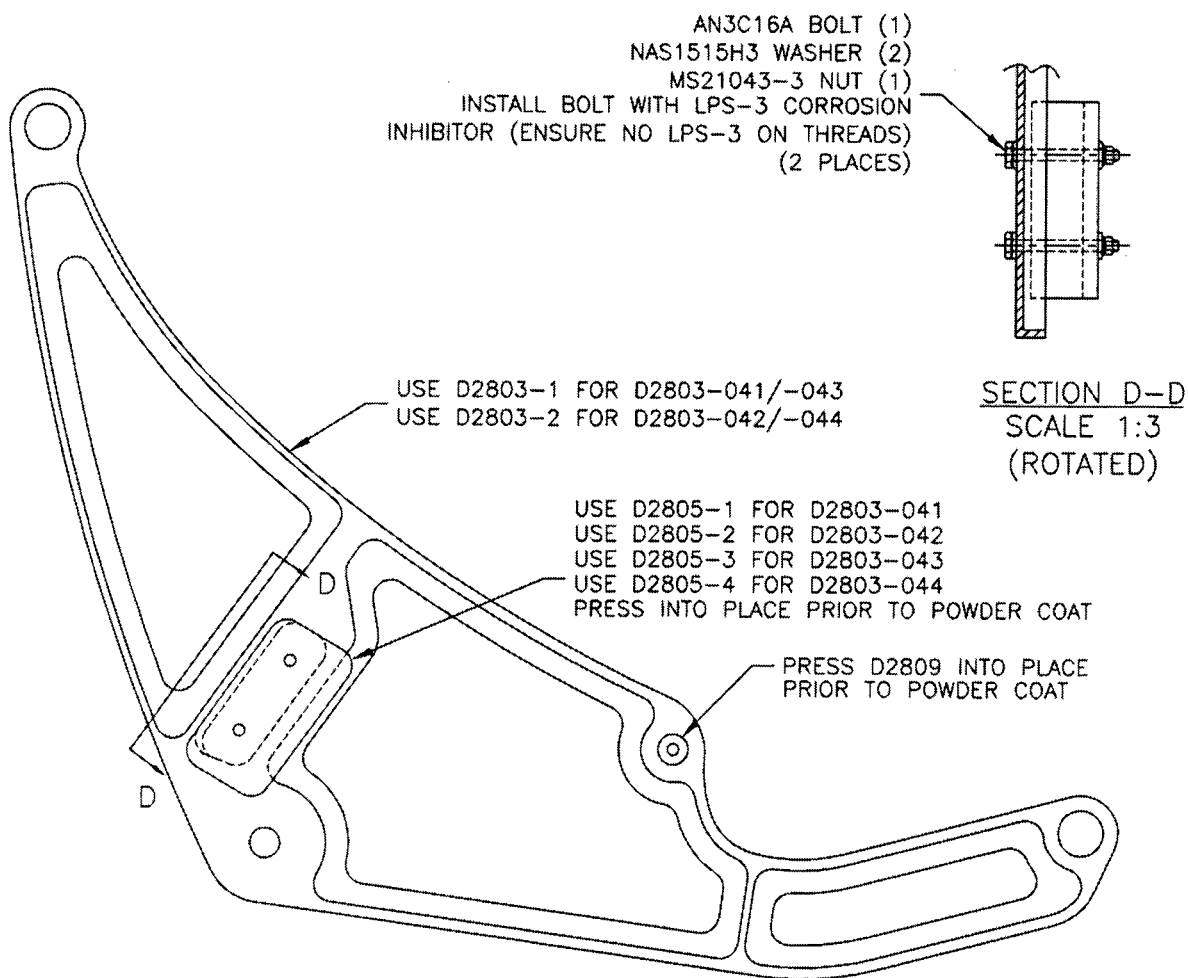
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03.11

03945

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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